

Date: Tuesday, 19/08/2008 4:04:37 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP SPACER		
Job Number	: 41445B		Part Number	: D30653		
Estimate Number	: 10378		Drawing Number	: D3065 REV. B		
P.O. Number	:		Project Number	: N/A		
This Issue	: 19/08/2008 S.O. No. :		Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	: / / Type : SMALL /MED FAB		Due Date	: 30/09/2000 Qty: 50 Um: Each		
Previous Run	: 39861B					
Written By	:					
Checked & Approved By	: <u>JUL 08-8-19</u>					
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF Est Rev:D Now on Water Jet 06-04-11 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet
		 Comment: Qty.: 0.2287 sf(s)/Unit Total: 11.4345 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch: <u>106272 HB 8-9-29</u> <u>107461 HB 8-10-10</u>
2.0	WATER JET	FLOW WATER JET
		 Comment: FLOW WATER JET 1-Cut as per Dwg D Dwg Rev: <u>B</u> Prog Rev: <u>B</u> <u>HB 8-9-29 HB 8-10-10</u> <u>HB 8-9-29 HB 8-10-10</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		 Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Stack
		<u>1/4 Due at 06/02/22</u>
		 <u>Solide</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC: Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 41445B		Part Number: D30653
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Bend as per Dwg D3065		<i>8/08/10/15 (60)</i>
7.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		<i>8/08/10/29 (61)</i>
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		<i>8/08-10-30 (61)</i>
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT CHEMICAL CONVERSION COAT		<i>F2 08/10/30 (61)</i>
10.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>Sylvie</i>		<i>8/10/30 (61X)</i>
11.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		<i>SP 08/11/03 (61)</i>
Job Completion		<i>MF 08-10-30</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41445B
Description: Step Spacer	Part Number:	D3065-3
Inspection Dwg: D3065 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

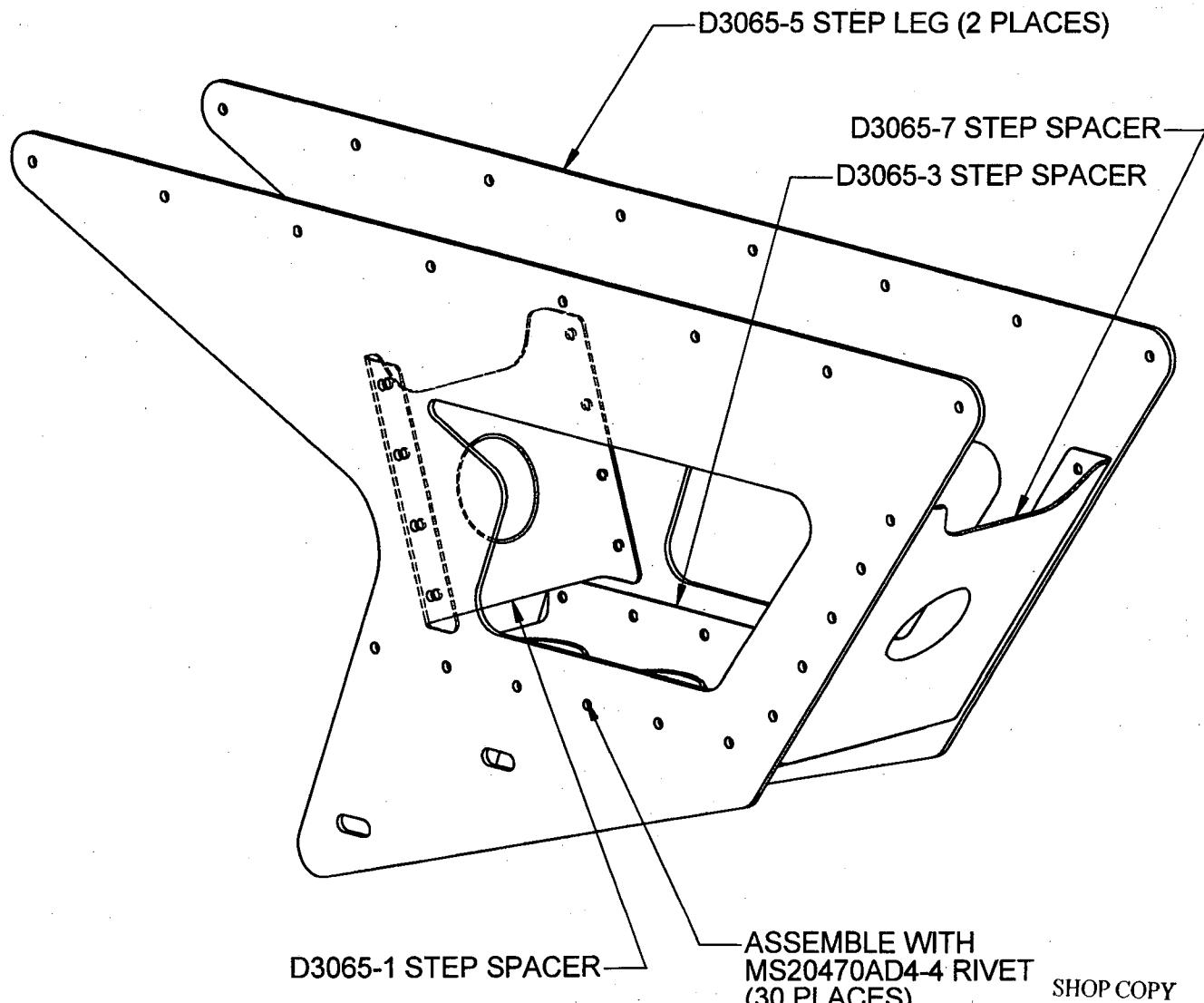
X First Article Prototype

Measured by:	HS	Audited by:	✓	Prototype Approval:	N/A
Date:	8-9-29	Date:	8/10/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue P/O D3065-041	KJ/RF	
B	04.08.12	Removed dimension 1.204	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	
D	07.09.06	0.040 dimension added	KJ/JLM	Z

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED*06.06.20 [Signature]*

D3065-041 STEP LEG ASSEMBLY

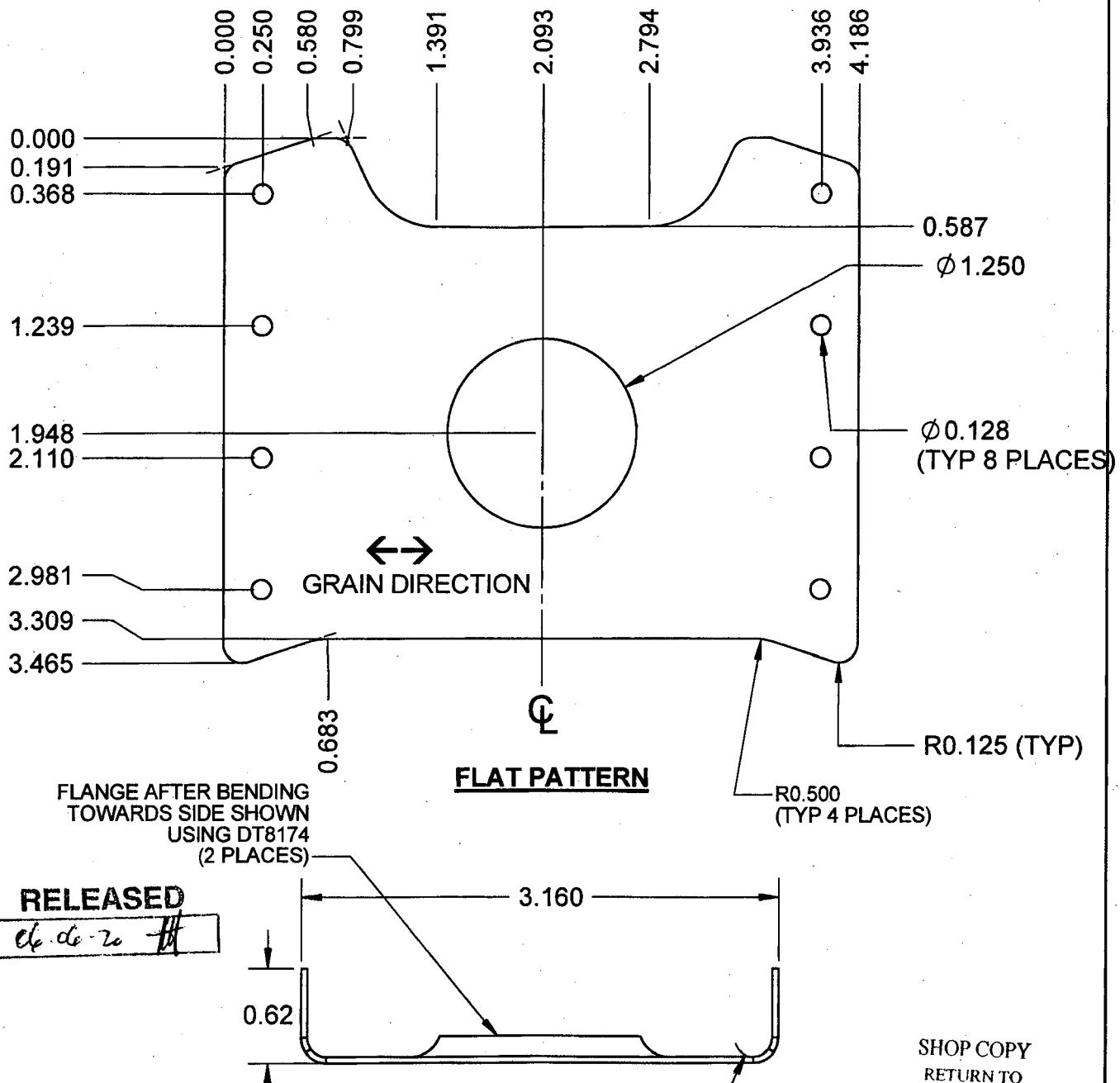
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CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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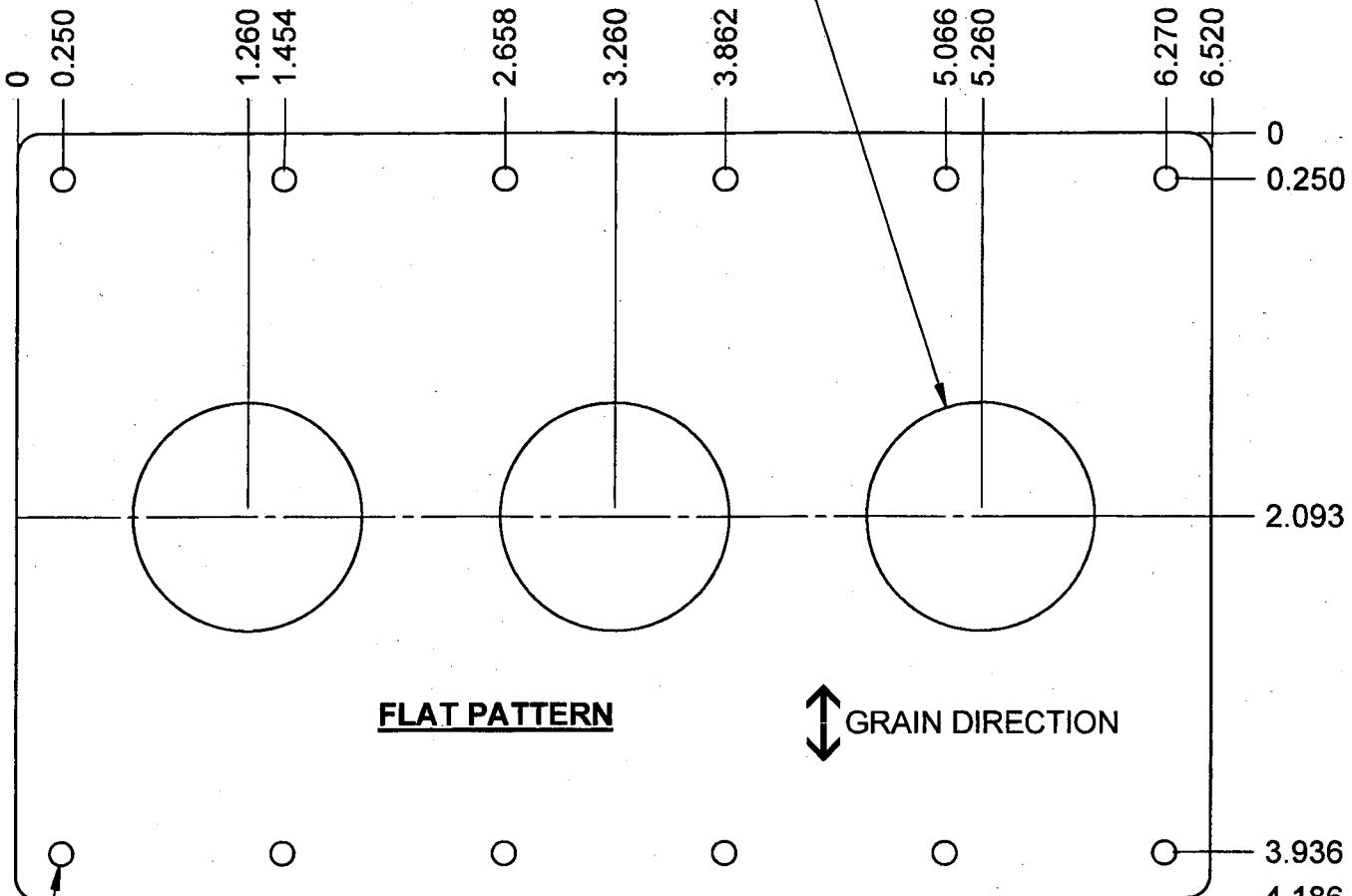
AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41445B

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DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1	

 $\phi 1.250$ (TYP, 3 PLACES) $\phi 0.129$ (TYP, 12 PLACES)RELEASED
*06.05.20 MM***D3065-3 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

BEND DETAIL

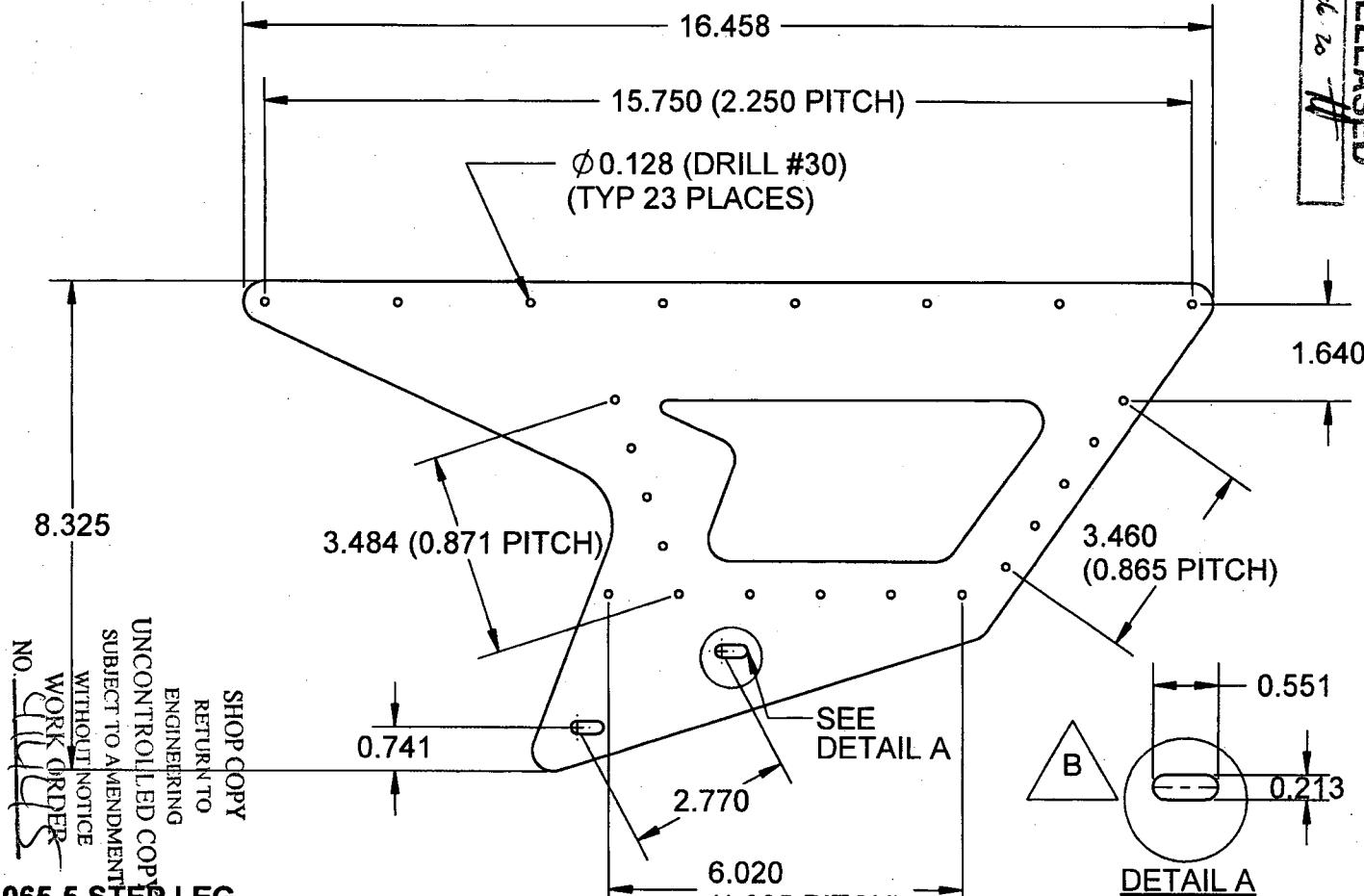
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CJ	C.B.	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
PH	JH	D3065
DATE	06.05.23	TITLE
		STEP LEG ASSEMBLY
		REV. B
		SHEET 4 OF 5
		SCALE 1:3

RELEASED
06.06.20 H**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1	

